

Date: Tuesday, 10/02/2009 11:09:07 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOOR WEDGE
Job Number :	45666		
Estimate Number :	12110		
P.O. Number :		Part Number :	D32001
This Issue :	10/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3200 REV A
First Issue :	1/1	Project Number :	N/A
Previous Run :	40253	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	JLD 09.02.10	Due Date :	05/03/2009
Comment :	Est Rev:A Removed from 9 Digit 06-01-25 JLM		

20

Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 0.0525 sf(s)/Unit Total : 0.3150 sf(s)
 UHMW 1" Black
 Material: Black UHMW 0.95" or 1.00" thick
 Use bearpaw scrap material
 (MUHMWB10)
 Identify for D3200-1
 Batch: MID6/K61

J.F. 09/02/13 (20)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 2.700" x 2.700

J.F. 09/02/13 (20)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3200-1 as per Folio FA337 and Dwg D3200

2-Deburr

DJP 09/02/14

(20)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 09/02/14

(20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 11:09:07 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR WEDGE

Job Number: 45666

Part Number: D32001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

88 09/02/17 (20)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 76

9/2/14

(20)

50

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/18

Job Completion



mt 09-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <i>451660</i>
Description: Door Post Block		Part Number: D3200-1
Inspection Dwg: D3200	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

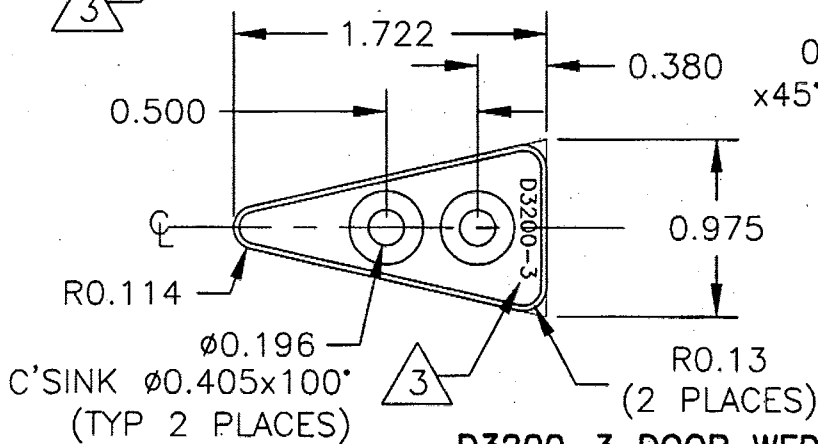
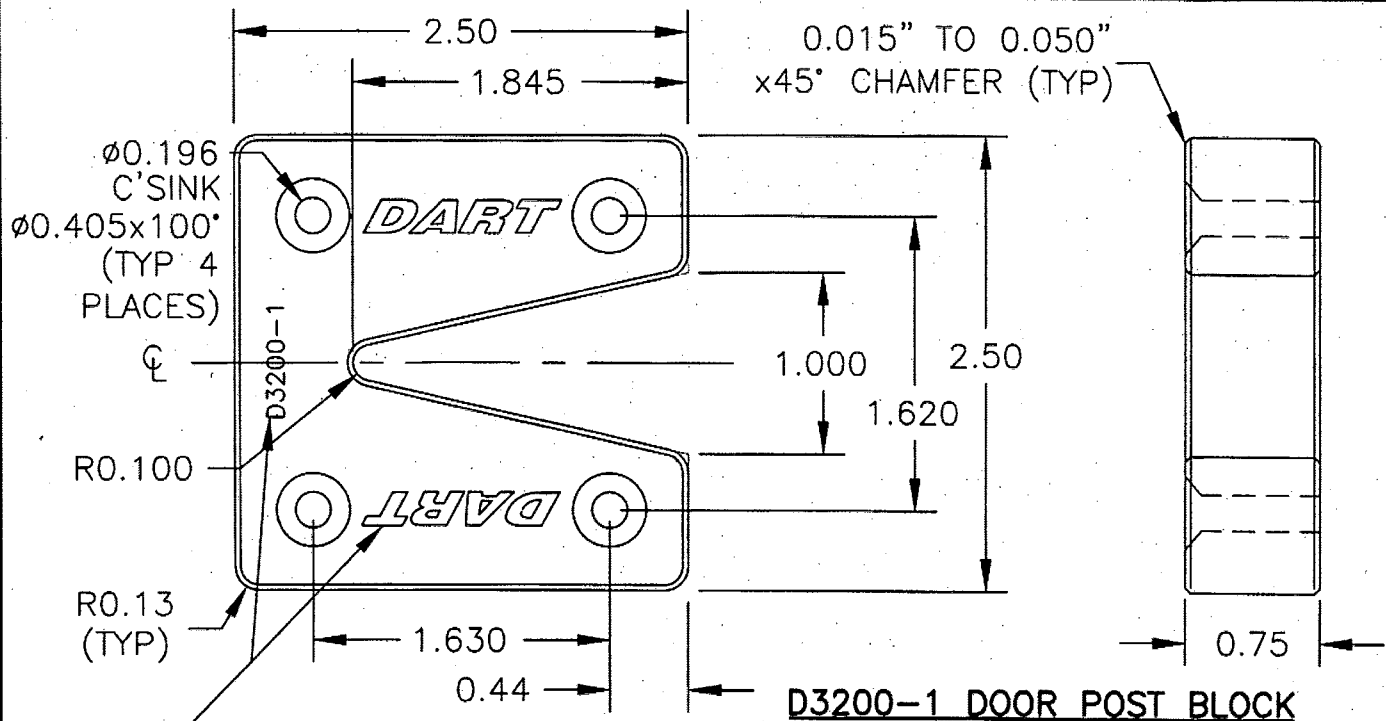
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005 -0.000	0.196	✓			
0.405 x 100°	+/-0.010	0.415	✓			
R0.100	+/-0.010	0.100	✓			
R0.130	+/-0.010	0.130	✓			
1.630	+/-0.005	1.625	✓			
0.440	+/-0.030	0.435	✓			
2.500	+/-0.010	2.504	✓			
1.845	+/-0.010	1.841	✓			
0.015 – 0.050	N/A	0.048	✓			
1.000	+/-0.010	1.000	✓			
1.620	+/-0.005	1.615	✓			
2.500	+/-0.030	2.503	✓			
0.750	+/-0.030	0.748	✓			

Measured by: <i>DJP</i>	Audited by: <i>SP</i>	Prototype Approval:	N/A
Date: <i>09/02/14</i>	Date: <i>09/02/17</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue	P/O D412-698-015	KJ/RF <i>[Signature]</i>

DART

DESIGN <i>LP</i>	DRAWN BY <i>LP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3200	REV. A SHEET 1 OF 1
DATE 03.08.06		TITLE DOOR WEDGE	SCALE 1:1
A	03.08.06	NEW ISSUE	

**D3200-3 DOOR WEDGE****D3200-1/-3**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. *4546*